

Date: Friday, 17/08/2007 11:19:46 AM
 User: Linda Lacelle

Process Sheet

split v10
 SS 07/09/26

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : INLET ADAPTER
Job Number : 34069	
Estimate Number : 12174	
P.O. Number : <i>N/A</i>	Part Number : D3478041
This Issue : 17/08/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3478 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL / MED FAB	Drawing Revision : B
Previous Run : 28520	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 11/09/2007
Checked & Approved By : <i>[Signature]</i>	Qty: <i>78</i> Um: Each
Comment : Est Rev: A New Issue 06-02-03 JLM Est Rev: B As per Rev B 06-05-24 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D34783	TUBE
-----	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	D3478-3	Tube	<i>B35236-x 2mx, B 28570 x 2mx.</i>
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mf

2.0	D34781	FLANGE
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	D3478-1	Flange	<i>B34086 x 4mx</i>
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mf

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3478

2-Spot Weld as per Dwg D3478 and Dart QSI 018

mf 07-10-19

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/09/24	3	Split w/o	SB	07/09/24	3		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 07/10/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 17/08/2007 11:19:46 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INLET ADAPTER

Job Number: 34069

Part Number: D3478041

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC11

VISUAL INSPECTION OF SPOT WELDING



Comment: VISUAL INSPECTION OF SPOT WELDING

SB 07/10/22 (4)

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/10/22 (4) PTD

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with a permanent fine point marker and Stock

Location: _____

PC 7/10/22 (4)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

7/10/22 (4)

Job Completion



U 07/10/22

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

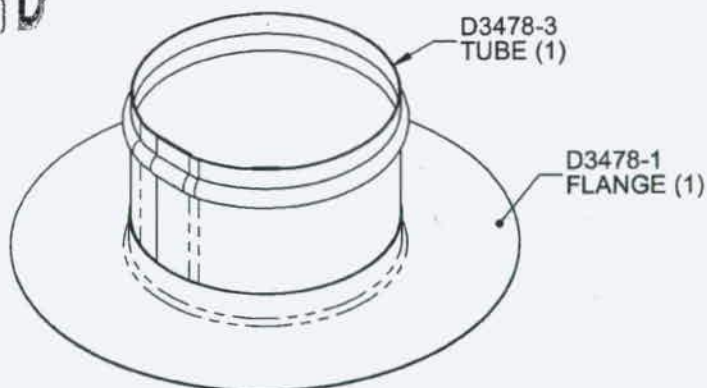
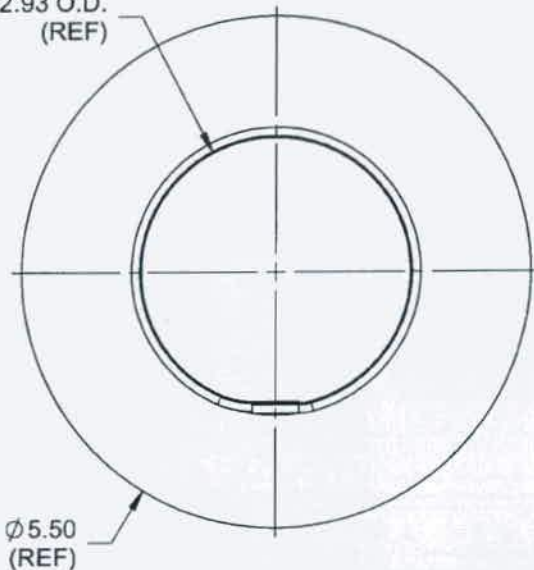
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/10/19	3	1 tube 3478-3 scrap, 1 flange 3478-1 scrap. Assemble wrong side R.C. Hammer error	<i>[Signature]</i>	Scrap & destroy	m.f. 07-10- 19	<i>[Signature]</i> 07/10/22	<i>[Signature]</i>	<i>[Signature]</i> 07/10/22

NOTE: Date & initial all entries

DART

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3478	REV. B SHEET 1 OF 7
DATE 06.05.16		TITLE AIR INLET ADAPTER	SCALE 1:2
A	05.12.08	NEW ISSUE	
B	06.05.16	REDESIGN D3478-5, ADD D3478-7, D3478-9S/-9	

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WORK ORDER
NO. 34069**D3478-041 AIR INLET ADAPTER****NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3478-041 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3478-041	AIR INLET ADAPTER
1	D3478-1	FLANGE
1	D3478-3	TUBE

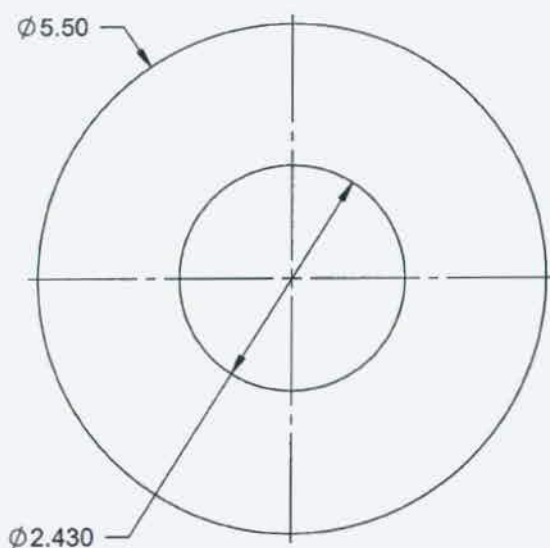
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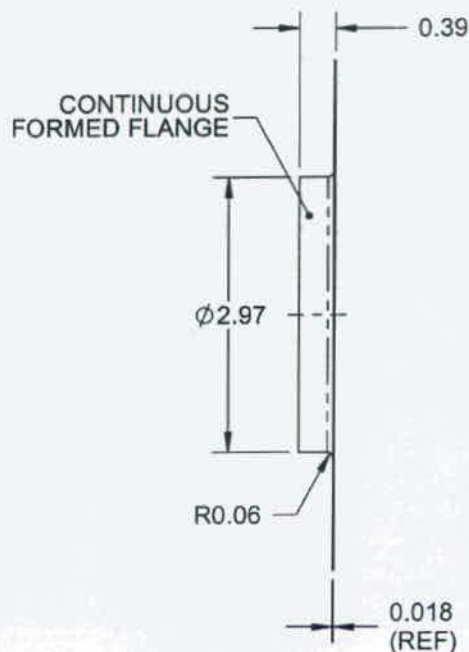


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DATE 06.05.16		TITLE AIR INLET ADAPTER	SCALE 1:2

RELEASED
06 05 16 #



**D3478-1F FLANGE
FLAT PATTERN**



**D3478-1
FLANGE**

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

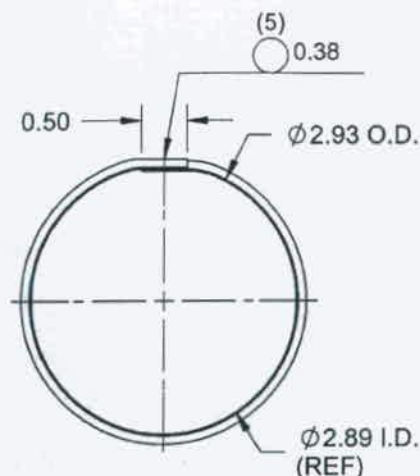
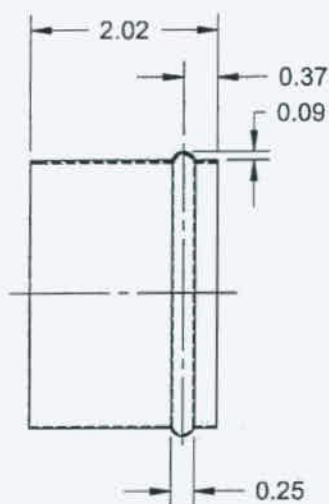
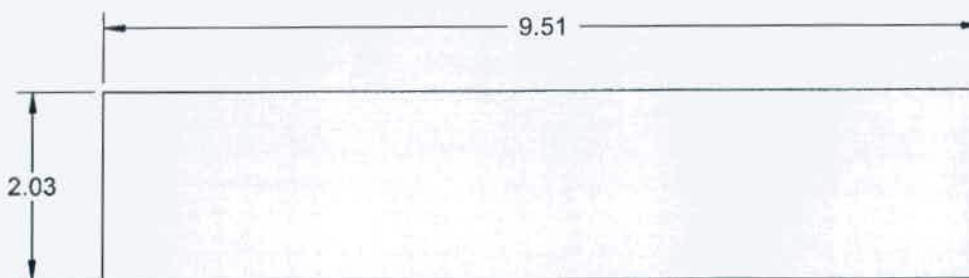
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CHECKED H	APPROVED H	DRAWING NO. D3478	REV. B SHEET 3 OF 7
DATE 06.05.16		TITLE AIR INLET ADAPTER	SCALE 1:2

RELEASED
06.05.16**D3478-3 TUBE****D3478-3F TUBE FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) SPOT WELD PER DART QSI 018
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

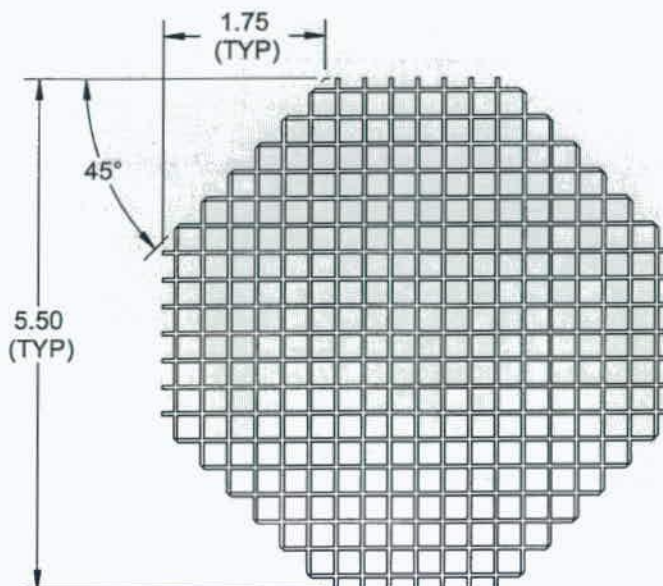
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DATE 06.05.16		TITLE AIR INLET ADAPTER	SCALE 1:2

RELEASED
06.05.16 *H***D3478-5 SCREEN****NOTES:**

- 1) MATERIAL: #4 MESH SCREEN, 0.203" OPENING, ϕ 0.047" WIRE
(REF. DART SPEC. M304MS4.203-.047)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE 06.05.16		TITLE AIR INLET ADAPTER SCALE 1:1	

RELEASED
06.05.16 *#*



D3478-7 INLET GASKET

NOTES:

- 1) MATERIAL: RED (OR GRAY) 60 DUROMETER HI-TEMPERATURE SILICONE SHEET, 0.063 THICK (REF. DART SPEC. M-SIL60-S.063)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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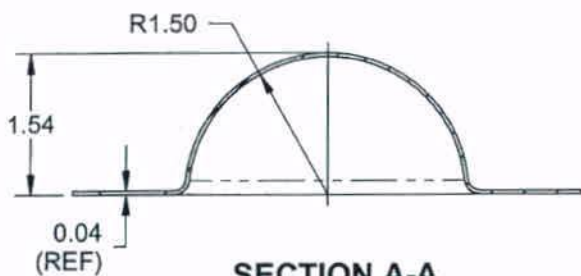
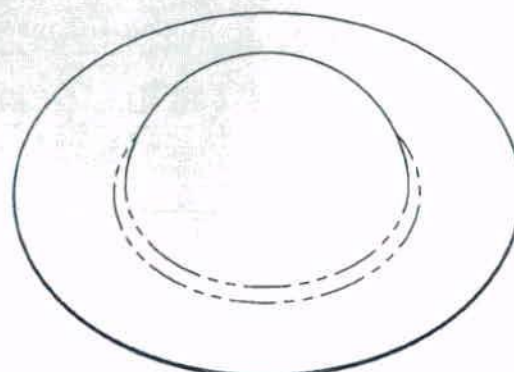
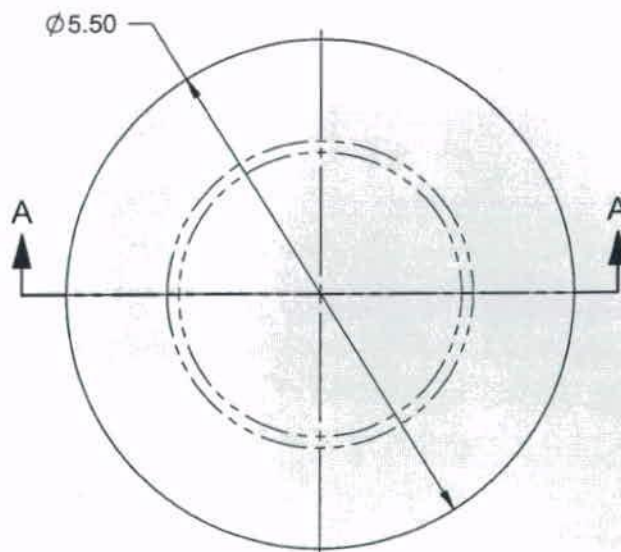
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DATE 06.05.16		TITLE AIR INLET ADAPTER	SCALE 1:2

RELEASED
06.05.16



SECTION A-A

D3478-9S AIR INLET SCOOP, SPINNING DETAIL

NOTES:

- 1) MATERIAL: 2024-0 ALUMINUM SHEET, 0.040" THICK PER AMS-QQ-A-250/4 OR AMS 4037 (REF. DART SPEC. M2024T0S.040)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

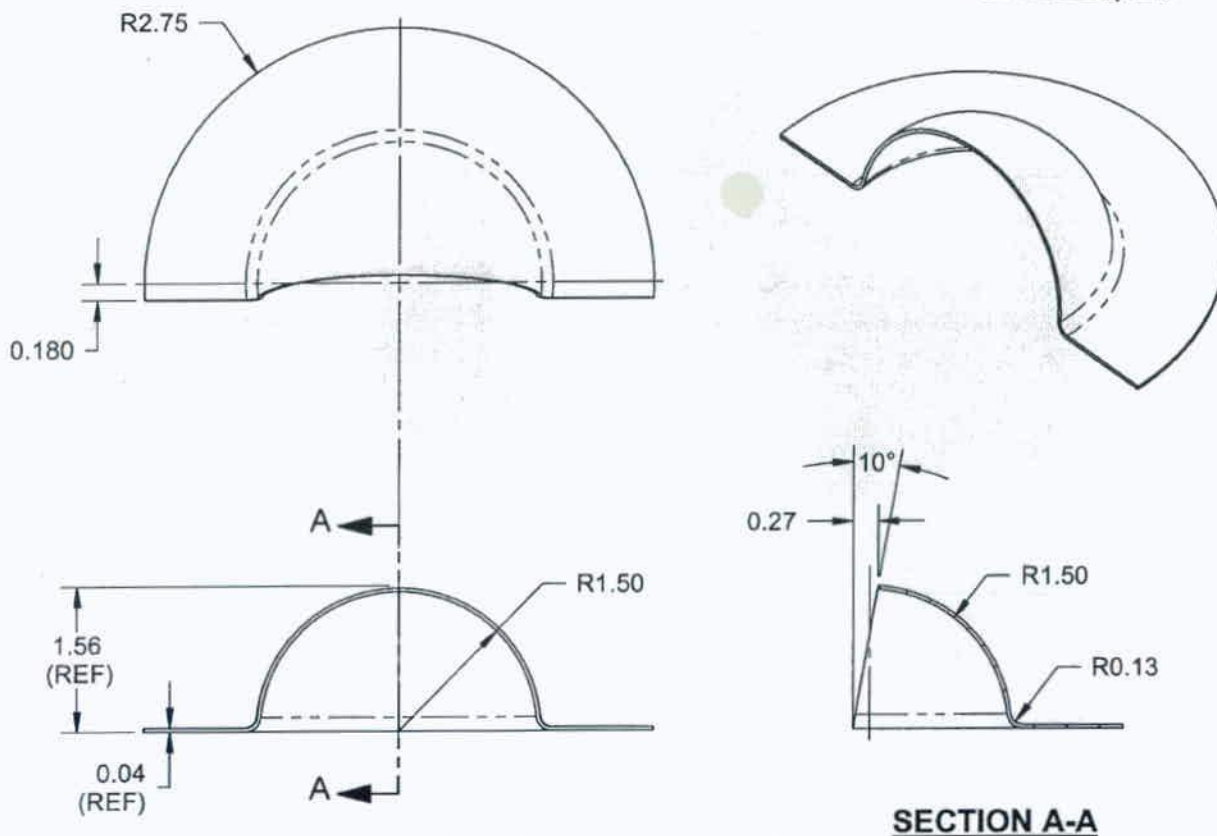
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CHECKED	APPROVED	DRAWING NO. D3478	REV. B SHEET 7 OF 7
DATE 06.05.16	TITLE AIR INLET ADAPTER		SCALE 1:2

RELEASED
06.05.16**D3478-9 INLET SCOOP****NOTES:**

- 1) MATERIAL: MAKE FROM D3478-9S
- 2) IDENTIFY WITH DART P/N D3478-9 USING FINE POINT PERMANENT INK MARKER
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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SPOT WELD TEST RECORD
AMS-W-6858A
CLASS 'C'

TEST NO#: 27

EMPLOYEE: Melani Fauten

PART NUMBER: D3478-041

JOB NUMBER: B34069

MATERIAL TYPE: 304L

MATERIAL THICKNESS: 0.017

GROUP SPECIFICATION



Group 1: Aluminum & magnesium



Group 2: Iron; nickel; cobalt



Group 3: Titanium, SS

TEST RESULTS

	PASS	FAIL
VISUAL:	[<input checked="" type="checkbox"/>]	[<input type="checkbox"/>]
PENETRATION:	[<input checked="" type="checkbox"/>]	[<input type="checkbox"/>]
PULL STRENGTH:	[<input checked="" type="checkbox"/>]	[<input type="checkbox"/>]

PSI Reading: _____

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 07/01/27
QUALIFIER: SB

